

Date: Tuesday, 16/06/2009 11:26:59 AM
 User: Melanie Fauteux

Process Sheet

| | | | | | | | |
|-----------------------|---------------------------------------|----------|------------------|------------------|--|------|----|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : BUSHING | | |
| Job Number | : 48613 | | | Part Number | : D26173 | | |
| Estimate Number | : 10308 | | | Drawing Number | : D2617 REV D2 | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 16/06/2009 | S.O. No. | : | Drawing Revision | : D2 | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : MACHINED PARTS | Due Date | : 16/06/2009 | Qty: | 10 |
| Previous Run | : 46606 | | | Um: | Each | | |
| Written By | : | | | Comment | : Est G 04.07.14 Reformat; added step 5 KJ/JLM | | |
| Checked & Approved By | : MF 09-06-16 | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | M6061T6T0375W058 | 6061-T6 RD Tube .375 x.058W | |
| | | Comment: Qty.: 0.0765 f(s)/Unit Total : 0.7655 f(s) 6061-T6 Round Bar 1.5" Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Batch: M110485 | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | |
| | | Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617 | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 | |

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X10)

Comment: Acid etch and Alodine as per QSI 005 4.1

UMD

09/06/16

7.0 QC5

INSPECT WORK TO CURRENT STEP



09/06/16 (10)

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST. 09-06-16

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/16 (10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-16

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 48613 |
| Description: Bushing | Part Number: | D2617-3 |
| Inspection Dwg: D2617 | Rev: D2 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

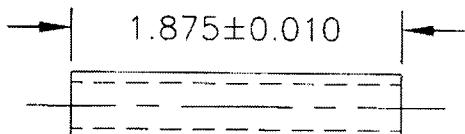
| | | | | | |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <i>ml</i> | Audited by: | <i>SD</i> | Prototype Approval: | N/A |
| Date: | 09/06/16 | Date: | 09/06/16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------|------------|--------------------|
| A | 04.08.09 | New Issue | KJ/JLM | |
| B | 06.03.08 | Dwg Rev change | KJ/JLM | <i>[Signature]</i> |

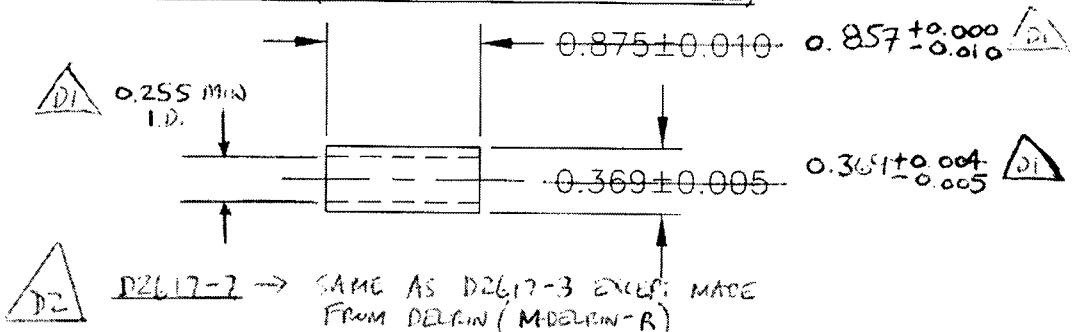


| | | | |
|-----------------|-------------|----------|---|
| DESIGN | BW | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>#</i> | APPROVED | DRAWING NO. D2617 |
| DATE | 01.07.04 | TITLE | SCALE |
| | | BUSHING | 1:1 |
| D2 04.04.10 H/P | ADD D2617-7 | A | 96.10.08 NEW ISSUE |
| | | B | 97.05.08 .875 WAS 1.125 |
| | | C | 97.06.04 0.369 DIA WAS 0.375 |
| | | D | 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE |
| | | DI | 04.07.12 <i>CORRECT TOLERANCE (ENGR 779)</i> |

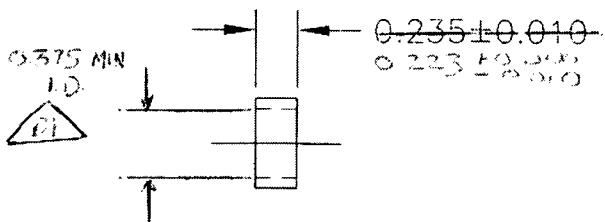
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



#48613

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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